Work Order ID 62813

Friday, October 08, 2010 12:45:11 PM



Page

Item ID:

D3463-7

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Drag Arm

Required Date: 10/15/2010

10/8/2010

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-8 Tooling:

Date:

Date:

Run

Start Stop

Stop



QC:

Date:

SPC (Y/N):

Accept

Reject

Insp. Number Stamp

Sequence ID/ Work Center ID Operation Description

Revision Nbr

Set Up/ **Run Hours**

Tool ID

Tool # Plan Qty Code

Qty

Reject

D3463

Rev B

100

Draw Nbr

Small Fab

Small Fab

Small Fab

Memo 1-Cut to 13.875"

2-Deburr

· Memo

3-Bend end as per dwg D3463

0.00

110

Quality Control

QC5- Inspect part completeness to step on W/O

120

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

1-Mill as per dwg D3463 2-Drill hole & ream to 0.4385" as per dwg D3463

3-Deburr



Dart Aerospac	e L	.td
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W/O:			WORK ORDER	CHANGES			•	1
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No) :	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	F	Resolution:	Disposition:	QA: N/C	Closed:		Date: _	

NCR:		1	E (NCR)					
		Description of NC		Corrective Action Section B		Verification	Approval	Annescal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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Work Order ID 62813

Friday, October 08, 2010 12:45:11 PM



Page 2

Item ID:

D3463-7

Setup Start



Revision ID:

Start Date:

Item Name:

Drag Arm

10/8/2010

Start Qty: 6.00

Reg'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Accept

Date: Date: Run

Start

Stop

Stop



Required Date: 10/15/2010

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool# Plan

Accept

Reject Qty

Reject Insp.

Work Center ID

130

Sequence ID/

Quality Control

Operation Description

QC2-Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

11/05/17

Code

Oty_

Stamp Number

140

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

150

Small Fab

Small Fab

Small Fab

Memo

Grind .450" rad 3

0.00

0.00

Dant Ae	ospace	Liu							•
W/O:			WC	RK ORDER CHANG	ES				* •
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition	n:	_ QA: N/C Ck	osed:		Date: _	
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DATE	CTED	Description of NC		ion B	Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID 62813

Friday, October 08, 2010 12:45:11 PM



Page 3

Item ID:

D3463-7

Revision ID:

Item Name: Drag Arm

Start Date: 10/8/2010

Start Qty: 6.00



Accept



Setup Start

Stop



Required Date: 10/15/2010

Reg'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/ **Run Hours**

0.00

0.00 D mostig

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Stamp Number

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

E 11-5-19

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Aeı	rospace	Ltd					•		
W/O:			WO	RK ORDER CHANGE	S	-			
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

Tuesday, October 12, 2010 2:31:11 PM

Work Order ID: 62813

Parent Item:

D3463-7

Parent Item Name: Drag Arm



Start Date: 10/8/2010

Required Date: 10/15/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV> A 05.11.18

new issue

EC

08-11-04 JLM Verified By:EC IPP Rev:B Added Step 7

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No				f	42.7012	1.15625	1.15625	,		
304 ss round tube .750 x .15										Mos		0/13/16	<u> </u>

304 ss round tube .750 x .120w

Location

MAT

Loc Qty

42.7012 42.7012 Loc Code

1/13625

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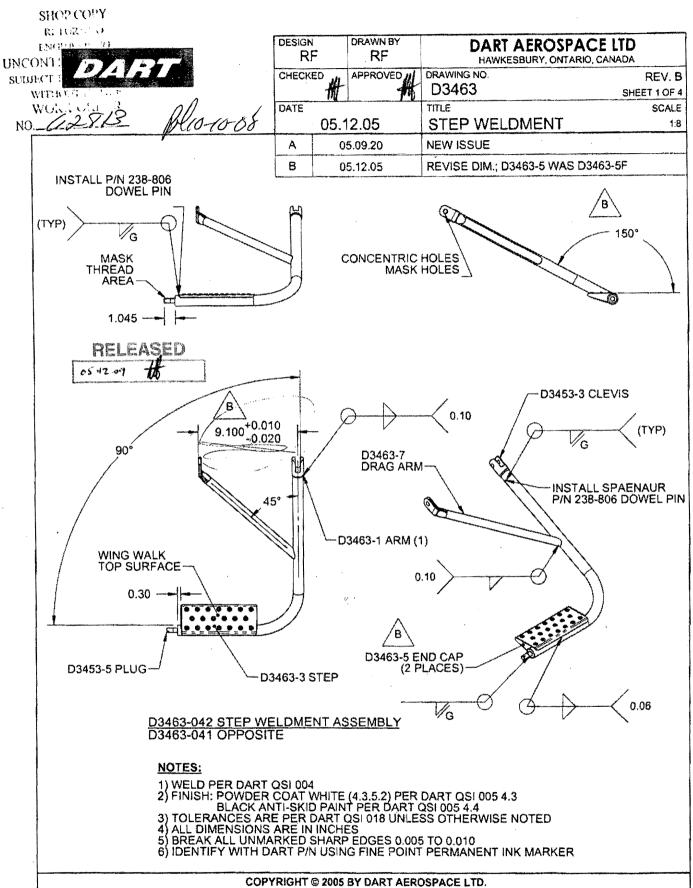
D3065-5DART AEROSPACE LTD	Work Order:	428/3
Description: Drag Arm	Part Number:	D3463-7
Inspection Dwg: D3463 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	riks	TARTICLE II		 1			
	L	X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		ments
13,5000	+0.000/-0.030	\frac{1}{2}				NOT REC	MTO. OTHER CA.
0.550	+/-0.010	.554			RA26	Vern	CA
Ø0.438	+0.006/-0.001	.554			RAD6	Ver	
R0.450	+/-0.030						
8,60	+.070	8.608			CNCOS	Verv	1
	4411						
		-					
							`
						*	
easured by:	A	Audited by:	B.A		Prototype A	pproval:	N/A
Date:	1/05/17	Date:	11/05	17		Date:	N/A
Rev Date	Change		, ,			Revised by	Approved
A 06.06.28	New Issue				K	(J/JLM A)	_GH_

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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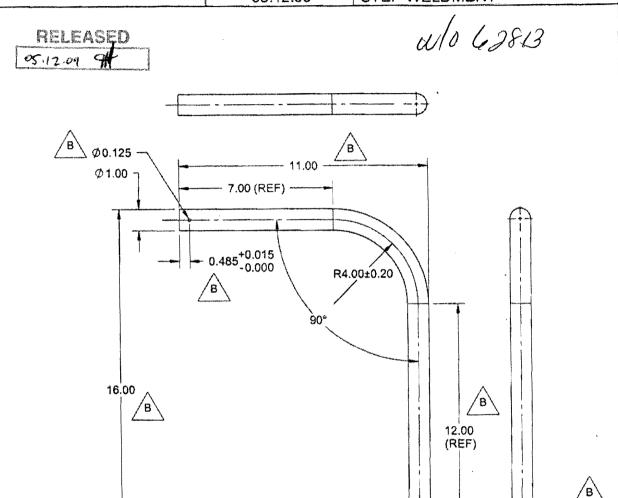
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CHECKED	APPROVED	DRAWING NO.	REV. B
1	AIL.	D3463	SHEET 2 OF 4
DATE		TITLE	SCALE
05.1	12.05	STEP WELDMENT	1:4



D3463-1 ARM

Ø0.125

 $0.610^{+0.015}_{-0.000}$

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

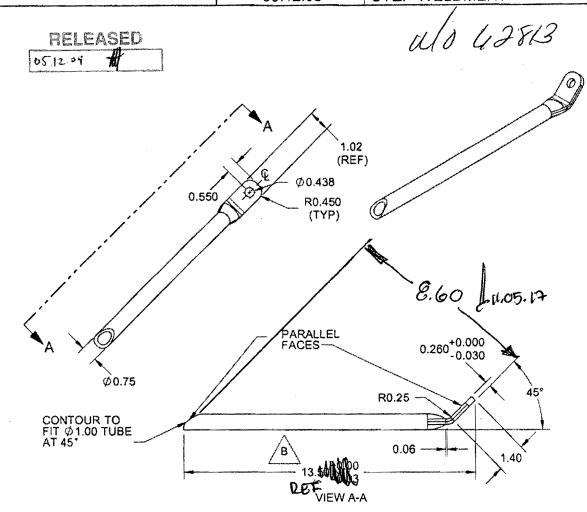
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٠,				By Date Qty Chief Eng. Prod Mgr Alt Category: NCR: Yes No DQA: Date: position: QA: N/C Closed: Date: ORDER NON-CONFORMANCE (NCR) Corrective Action Section B							
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CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
1 05	.12.05	STEP WELDMENT	1:4



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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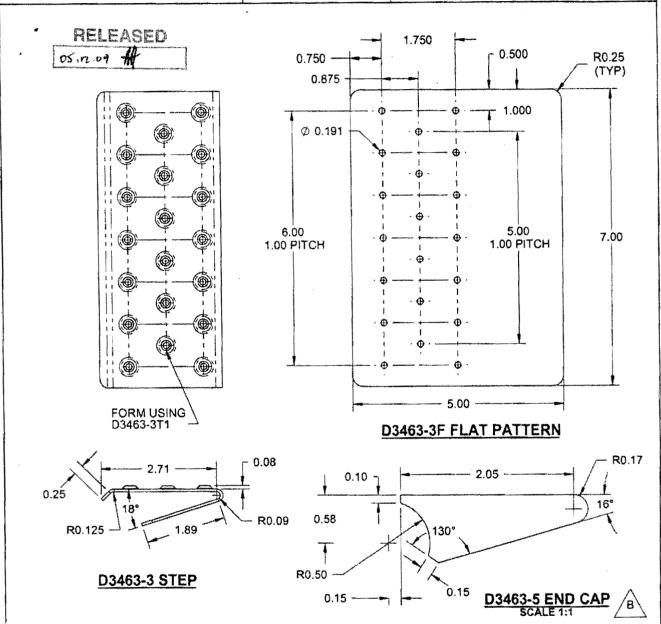
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d/o 62813



DESIGN RF	DRAWN BY RF	DART AEROSPA HAWKESBURY, ONTARIO	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 4 OF 4
DATE 05.1	12.05	STEP WELDMENT	SCALE 1:2



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)							
***************************************		Description of NC		Corrective Action Section B	Verification	Approval Chief Eng	Approval QC Inspector			
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